

[illegible]

Page 1

Accept

**Setup Start**

00000000000000000000000000000000

Stop

Abstract

[illegible]**Cust Item ID:**

Start Date: 6/29/2010 **Start Qty:** 16.00

Required Date: 7/6/2010 Req'd Qty: 16.00

Customer:

Reference:

Run Start

[illegible]

Date: 10-6-29

Tooling:

Date:

QC:


Date:

SPC (Y/N):

Date:

Stop



100

 Waterjet
 FLOW CNC Waterjet
 304 . 040

FLOW WATER JET
 Memo
 1-Cut as per Dwg D3535
 Deburr if necessary

0.00
 0.00
☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

B10-8-17
 (17)

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

QC8- Inspect parts - second check

0.00

Memo

0.00

B10-8-17

(17)

1B 10-8-17

17

81.9001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries





Work Order ID 60233

Tuesday, June 29, 2010 11:43:18 AM

Page 3

Item ID: D3535-39 Accept  Setup Start 
Revision ID:
Item Name: Wearshoe Stop 
Start Date: 6/29/2010 Start Qty: 16.00  Cust Item ID:
Required Date: 7/6/2010 Req'd Qty: 16.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		=) HU 10/08/23		X17	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-18</u> Memo	0.00 0.00		=) HU 10/08/23		X14	0		
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/08/23</u>  MF 10-8-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 11:43:22 AM

Page 1

Work Order ID: 60233

Parent Item: D3535-39

Parent Item Name: Wearshoe




Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	69.9836	0.951	16.01684	16.2	1310-8-17	

Location

Loc Qty

Loc Code

MAT

66.1278

114574

66.1278

MAT20

3.8558

112885

2.7475

113062

1.1083

115440

115440

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66233
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	h		T H301	
32.775	+/-0.010	32.775	h		T	
29.275	+/-0.010	29.275	h		T	
25.775	+/-0.010	25.775	h		T	
23.250	+/-0.010	23.250	h		T	
19.750	+/-0.010	19.750	h		T	
17.750	+/-0.010	17.750	h		T	
14.250	+/-0.010	14.250	h		T	
9.500	+/-0.010	9.500	h		T	
4.750	+/-0.010	4.750	h		T	
2.000	+/-0.010	2.000	h		V H300	
5.00	+/-0.030	5.00	h		T	
9.00	+/-0.030	9.00	h		T	
28.00	+/-0.030	28.00	h		T	
Ø0.188	+0.005/-0.001	.191	h		V	
1.885	+/-0.010	1.888	h		V	
0.300	+/-0.010	.304	h		V	
0.300	+/-0.010	.300	h		V	
0.038	+/-0.010	.035	h		V	

Measured by:	R
Date:	10-8-17

Audited by:	
Date:	100818

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

Dart Aerospace Ltd

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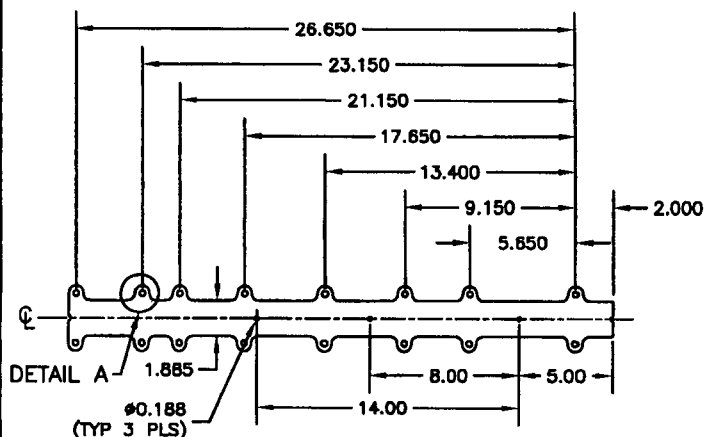
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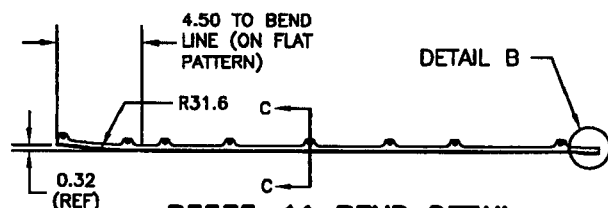
07.04.24

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

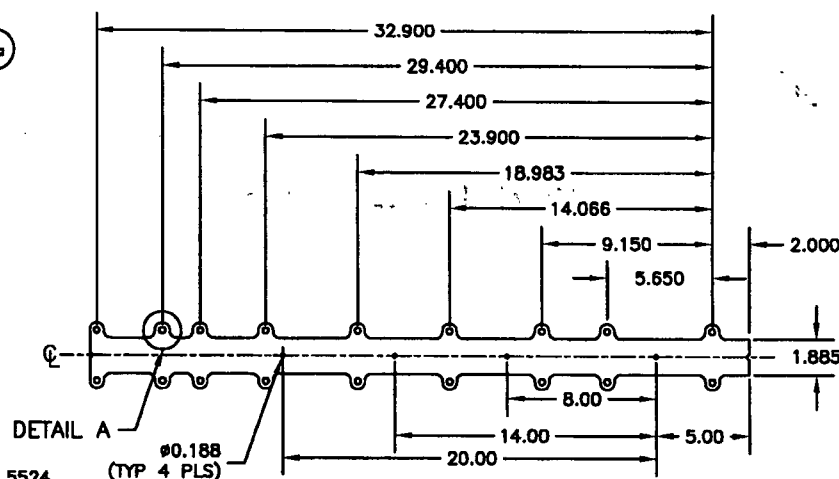
NO. 60233
BS 06-29



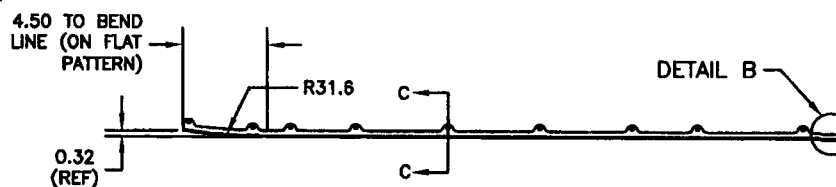
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE 1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

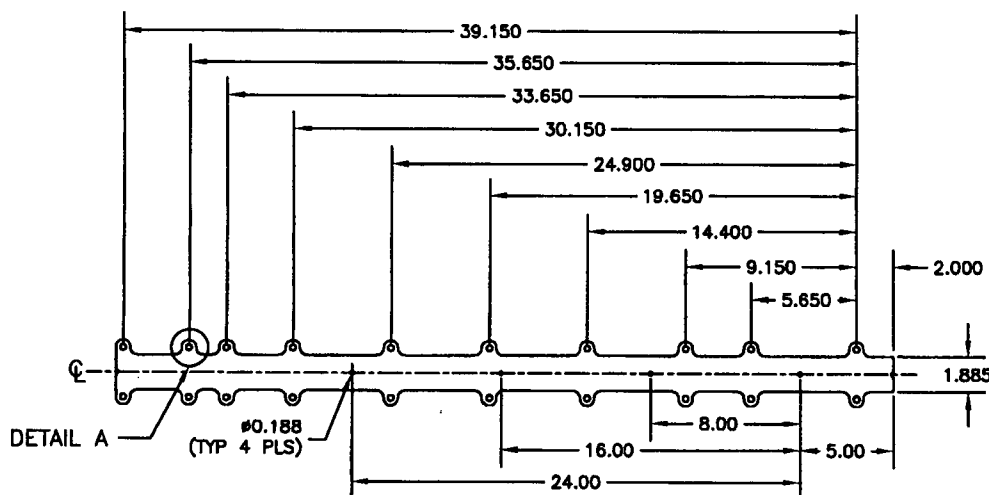
DART

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07.04.24

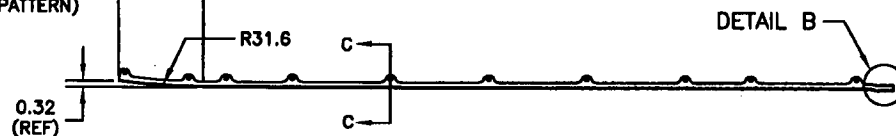
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C.B.	MH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

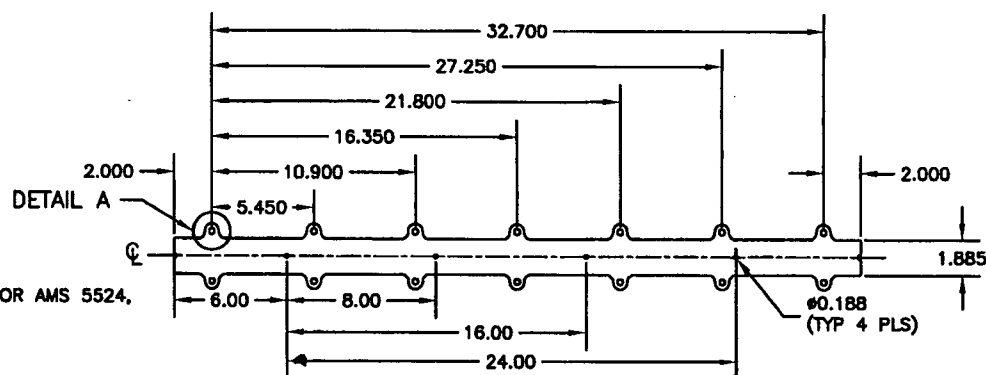


4.50 TO BEND
LINE (ON FLAT
PATTERN)

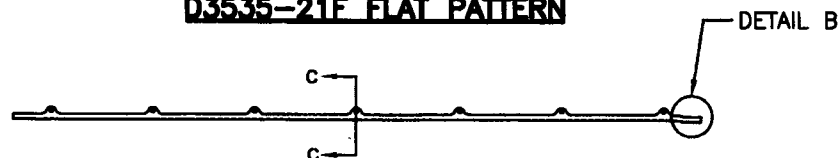
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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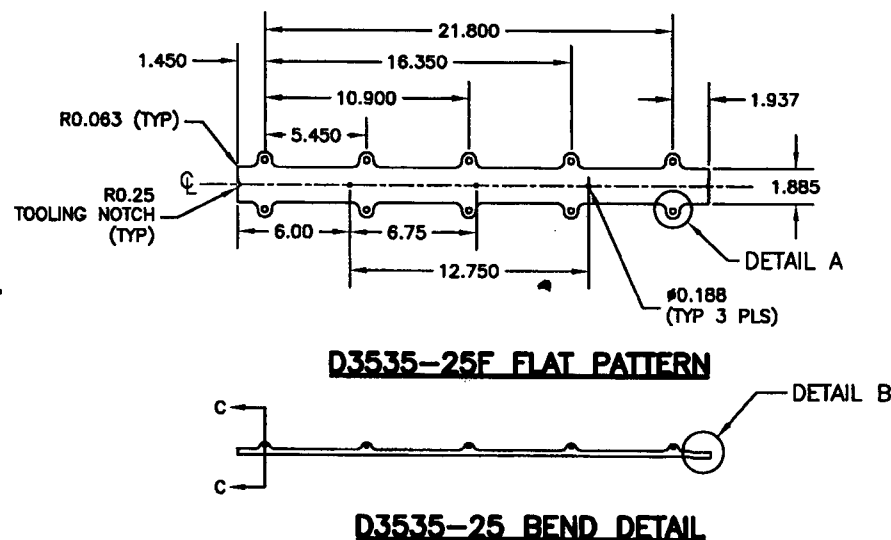
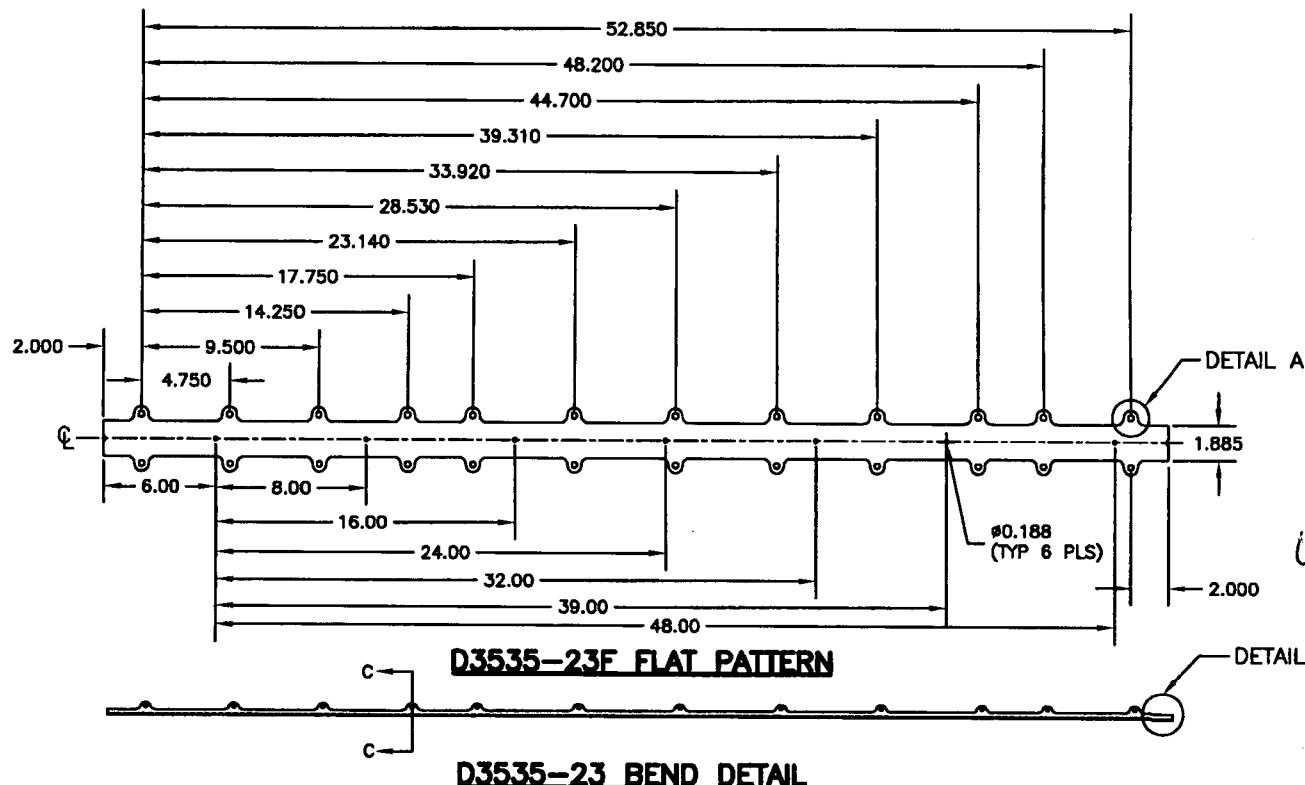
NOTE: Date & initial all entries

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07-04-24

W/0 60233

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	3 OF 7	SCALE
				1:10



NOTES

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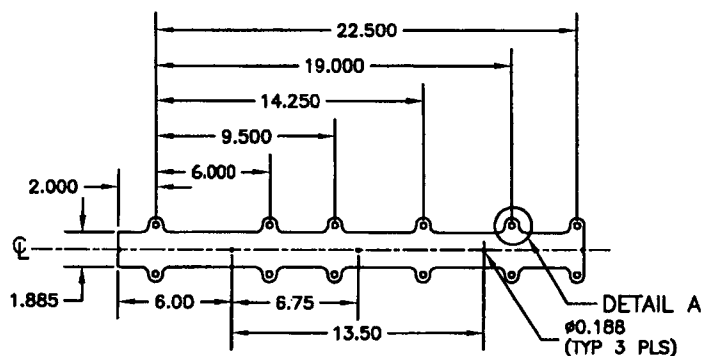
NOTE: Date & initial all entries

DART

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07.04.24

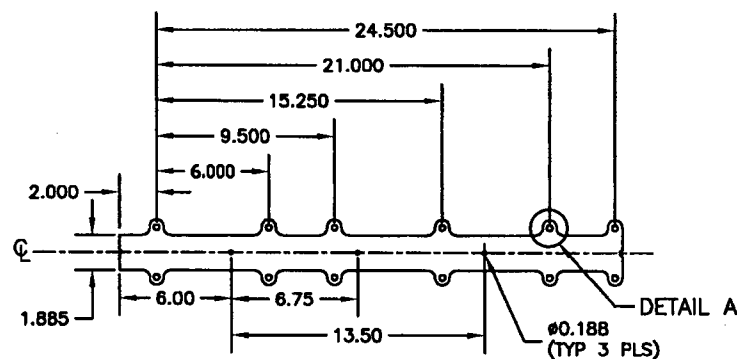
also 60233



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 4 OF 7
		D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

W/O:		WORK ORDER CHANGES					
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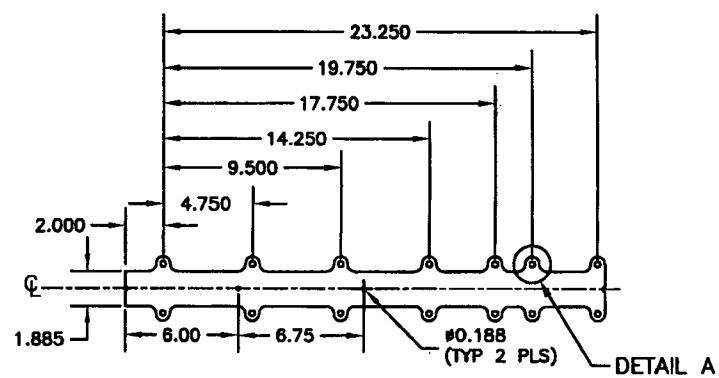
NOTE: Date & initial all entries

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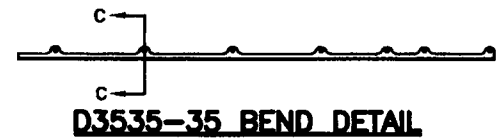
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07.04.24

wlo 60283

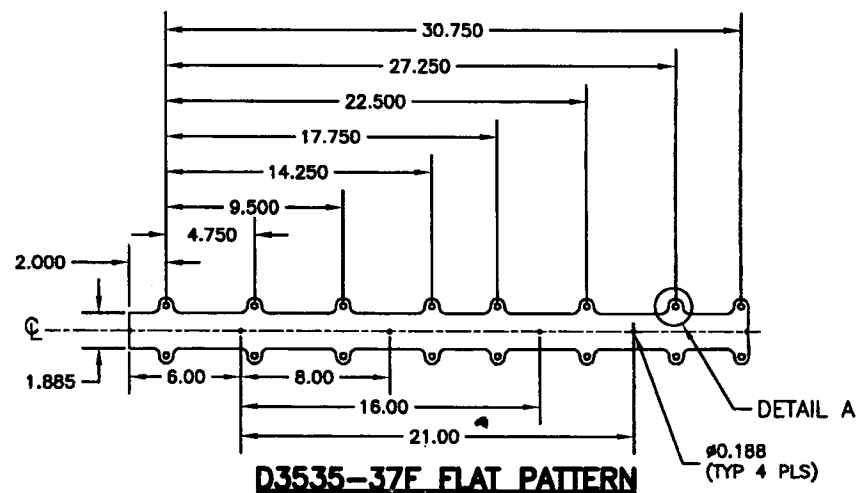
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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7
	SCALE 1:10	



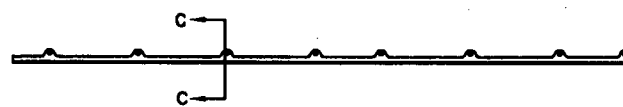
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

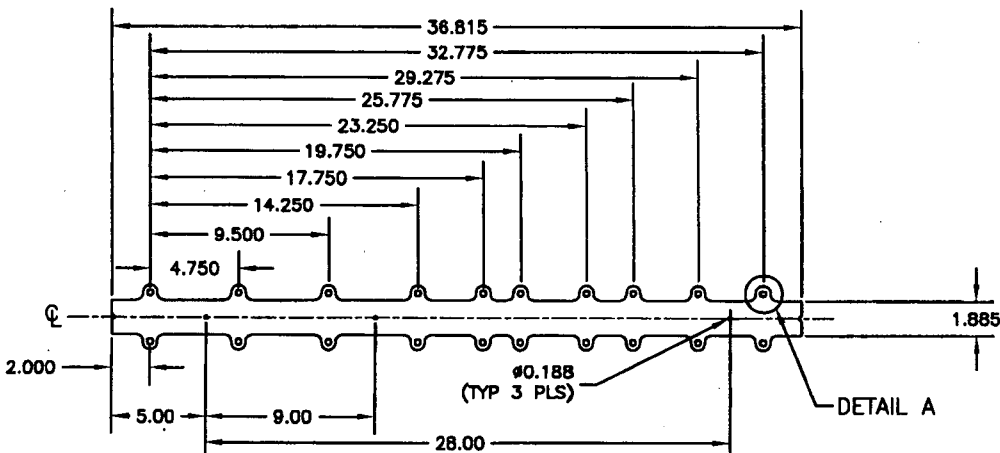
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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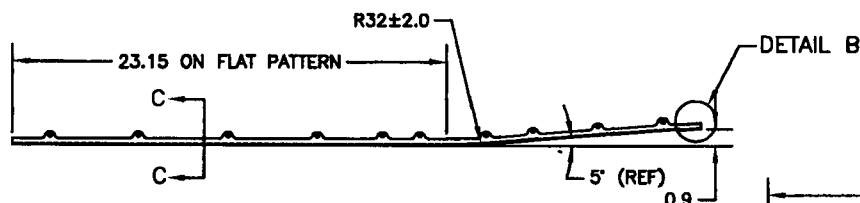
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

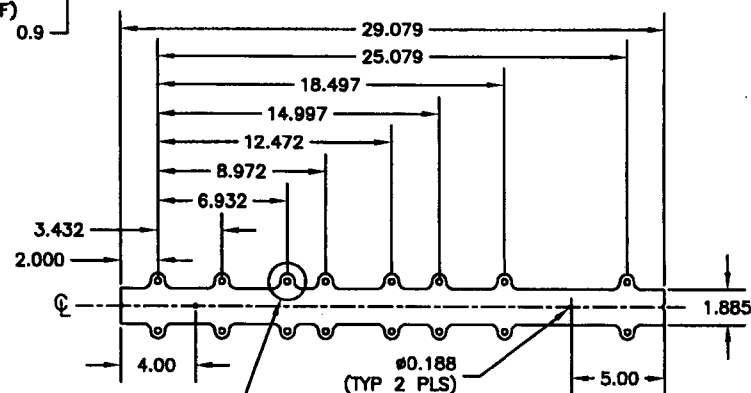
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07.04.14



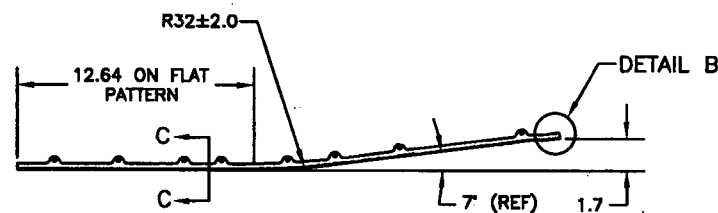
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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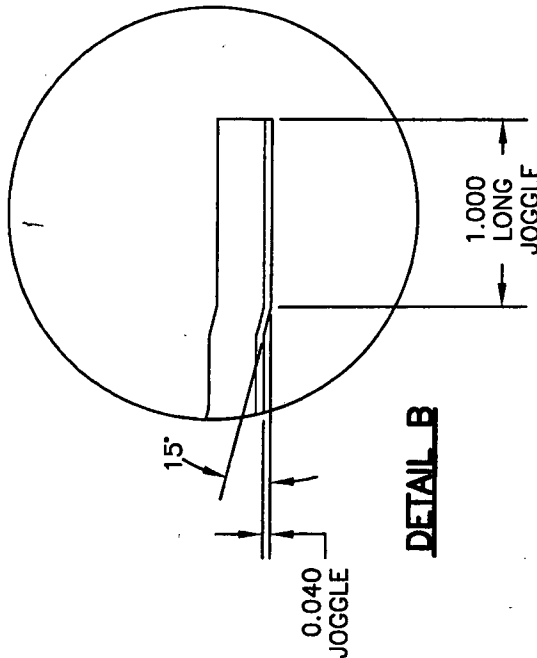
NOTE: Date & initial all entries



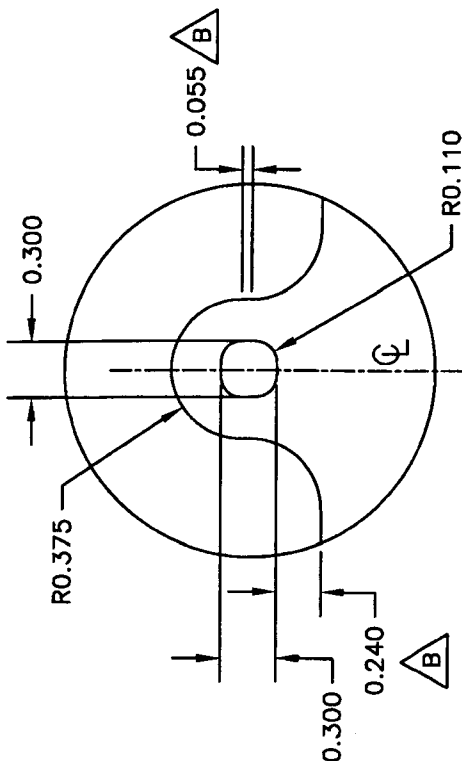
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

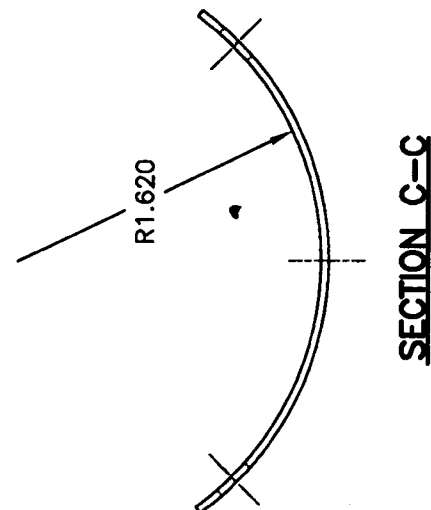
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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			Initial Chief Eng	Action Description - Chief Eng	Sign & Date			

NOTE: Date & initial all entries